

304 1.00

Work Order ID 68253



Page 1

Monday, April 11, 2011 10:30:50 AM

Item ID: D3493-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 4/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Handwritten signature

Date: 4-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3493

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA626 & Dwg D3493 2-Deburr

*Handwritten signature and date 11/5/11**Handwritten 41 and signature*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Handwritten signature and date 11/5/11**Handwritten 41 and signature*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Handwritten signature and date 11-5-11**Handwritten 41 and signature*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68253

Monday, April 11, 2011 10:30:50 AM



Page 2

Item ID: D3493-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 4/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Identify as per dwg & Stock Location: <u>62</u> Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/5/19 412

11/5/19

11.05.19
412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 10:30:56 AM

Page 1

Work Order ID: 68253

Parent Item: D3493-1

Parent Item Name: Washer




Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: A New Issue 06-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000  304 round bar 1.00		Purchased	No			100	f	65.8500	0.0291	1.225263		4/15/11	

Location

Loc Qty

Loc Code

MAT029

65.85

109508

12.5

→ 109541

5.18

113457

48.17

1.4 ft

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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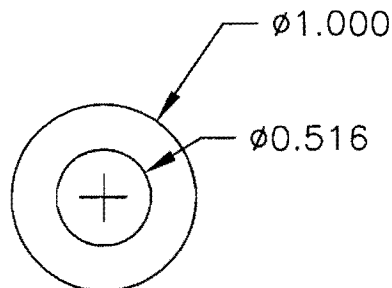
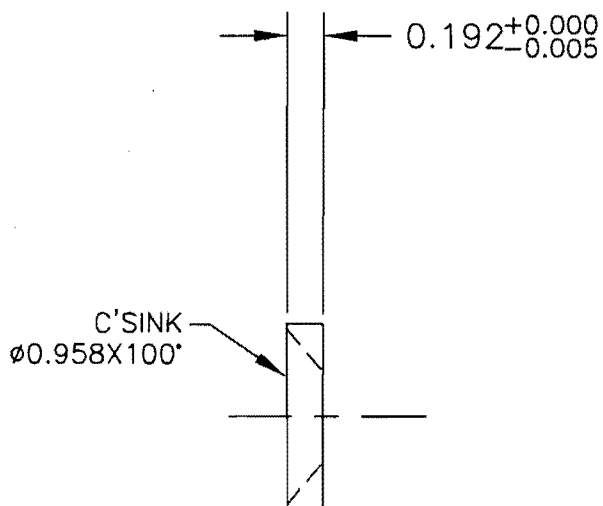
NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE WASHER	SCALE 1:1
A	06.01.04	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68253

11-09-11



D3493-1 WASHER

D3493-1 WASHER

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ϕ 1.000 ROUND BAR
(REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED
06.02.07 *[Signature]*

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Dart Aerospace Ltd

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